

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-67 Date Opened: 08-Jun-15 Title: MachiningAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: N/A Product Model: N/A Quantity: 96**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69823	1	Lugs	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

96
N/A
N/A
JR

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: J Rekve for M RekveSign: [Signature]SCA: AD01Date: 01-Jul-15

ICC / Dual Inspection performed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 01-Jul-15

Work Order closed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 01-Jul-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

LUG FABRICATION - 69823

General

These instructions apply to lug 69823-02. Refer to the following drawings, at the current revision, for dimensions and details:

69823, Revision 1 – Lug Fabrication

Work Order: 2015-67

x12 pcs.

Date Open: 08-Jun-15

96 parts - 2

Complete
(initial or SCA #)

AD06

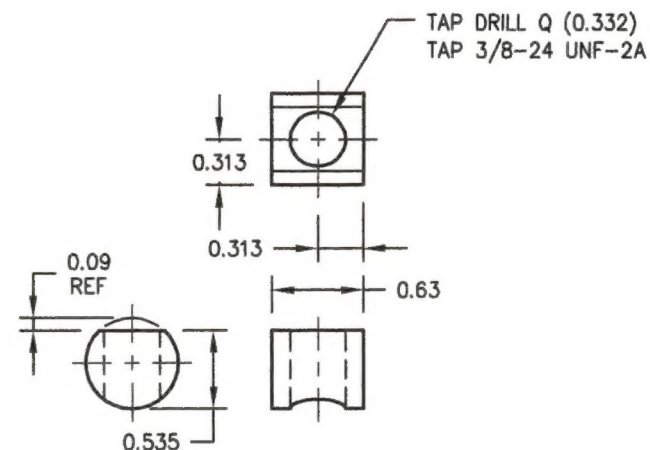
1. Lug Fabrication – 69823-02 (manual production)

PO#15015

- a. Cut 5/8" round 1018 mild steel material to 8".
- b. Record material PO on attached material list.
- c. De-burr cut ends using buffing wheel.
- d. On manual mill, install drill chuck.
- e. Align end of stock with edge of vise. Set X 0 at this edge.
- f. Find centre of stock by touching off on both sides. Set Y 0 at centre of stock.
- g. Using #3 (1/4") or #4 (5/16") centre drill @ 500 RPM:
 - i. Drill onto taper of centre drill at hole locations specified on drawing.
 - ii. Mark cut locations with a small dot, about 0.010" deep, as specified on drawing.
- h. Using #9 (0.196") drill bit @ 500 RPM, drill through stock at hole locations specified on drawing.
- i. Using Q (0.323") drill bit @ 250 RPM, drill through stock at hole location specified on drawing.
- j. Install tapping head, with 3/8-24 tap @ 90 RPM. Set depth to tap through stock, about 1/8" past bottom.
- k. Tap hole locations as specified on drawing.
- l. Install collet chuck.
- m. Using #7 centre drill (5/8") @ 500 RPM, deburr holes.
- n. Flip bar, insert 3/8-24 bolt without head into threaded hole. Grip bolt with collet or drill chuck to ensure alignment.
- o. Using a 5/8" end mill @ 750 RPM (or larger end mill), mill 0.09" off height.
- p. De-burr holes. De-burr edge on buffing wheel.
- q. Inspect lugs for conformity to drawing.
- r. Tag complete and inspected lugs and place into stock.

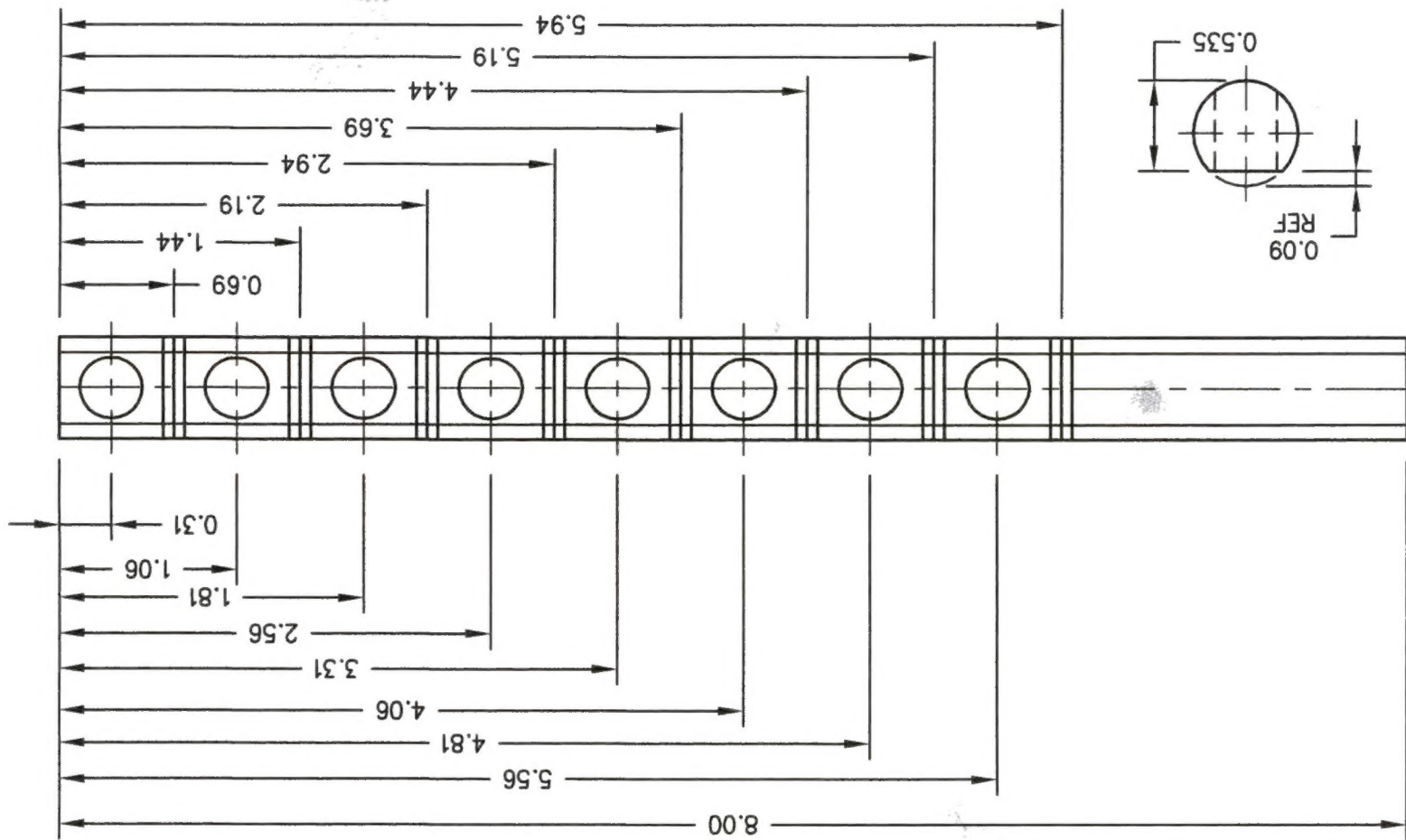
2015-67

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVE LUG (ITEM 1)	BJC	27/02/2007



02 LUG

69823-02	02	LUG	1018 MILD STEEL	ANSI 1010/1020	5/8 DIA ROD
	01				
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS				
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON		DATE 10 APR 2006		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net		
			BELL 206L, 407 QUICK RELEASE CARGO BASKET BASKET COMPONENTS - LUGS		
			SCALE 1 : 1 SHEET 1 OF 1		
		DWG. SIZE LGL		DWG. NO. 69823	
				REV. 1	



2015-67



WO# 2015-67

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013